

Work Order ID 83220-1

April-13-12 1:42:35 PM

Split 1/1

83220

U/R

Page 1

Item ID: D4154-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 13/04/2012 Start Qty: 5.00

Required Date: 27/04/2012 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MJS
QC:

Date: 12/04/13 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4154

B U/R

100

100

Large Fab

Large Fab

0.00

0.00

Memo

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

DT9756

2059 B Hardcoat Welding Rod

BATCH# M122036

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH# M120013

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

M 12-06-15 (2)

12-06-15
JBL

Work Order ID 83220

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Page 2

Item ID: D4154-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 13/04/2012 Start Qty: 5.00

Required Date: 27/04/2012 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

8/12/15

(72)

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154

B121960

AB 12-6-16 (2)

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8/12/18

(72)

Work Order ID 83220

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Page 3

Item ID: D4154-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 13/04/2012 Start Qty: 5.00

Required Date: 27/04/2012 Req'd Qty: 5.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

5

5

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

180

QC 21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/6/12

12/6/18
mf
12-0618

Picklist Print

April-13-12 1:42:40 PM

Page 1

Work Order ID: 83220

83220

Parent Item: D4154-041

D4154-041

Parent Item Name: Wearplate Assembly

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A 10.09.21 new issue DD ver:EC
10.11.04 added DT9684 DD ver:EC
per dwg revB DD ver:EC

IPP Rev:B
IPP Rev:C 11.04.14 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4154-1

Manufactured

No

84746 X2

100

Each

1.0000

1

5

**

12-06-15
JBL

D4154-1

Plate

Location

Loc Qty

Loc Code

WA

1

66312

1

D4155-1

Manufactured

No

100

Each

0.0000

1

5

**

12-06-15
JBL

D4155-1

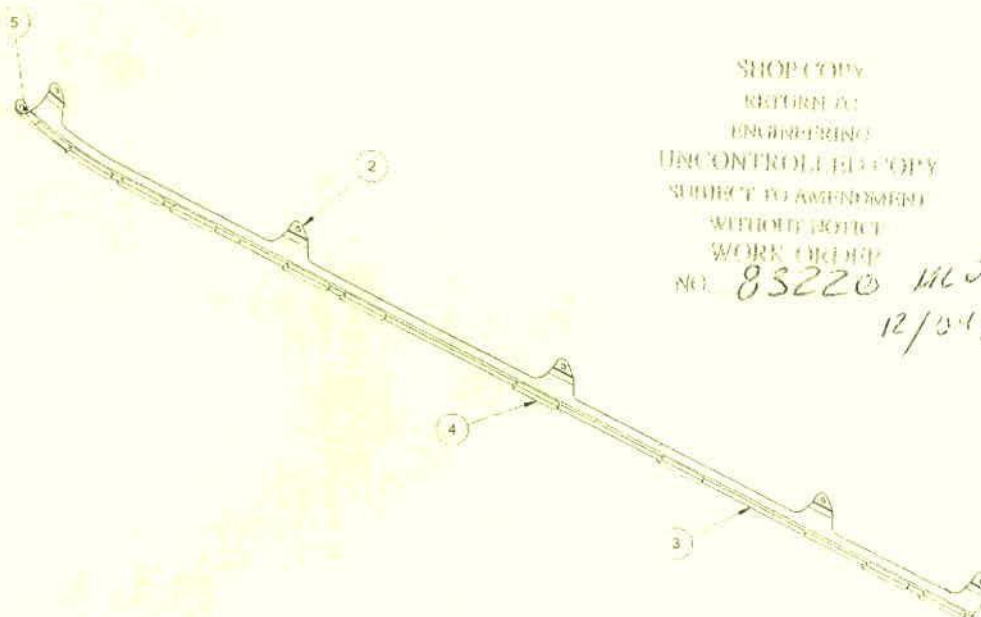
Bar

83846 X2

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT 2)

SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83220 MLJ
12/04/13

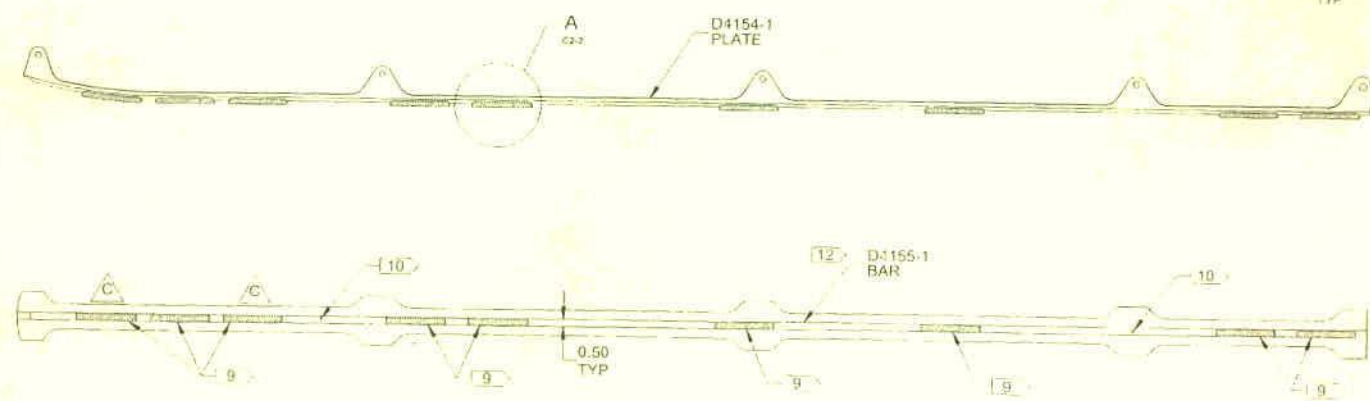
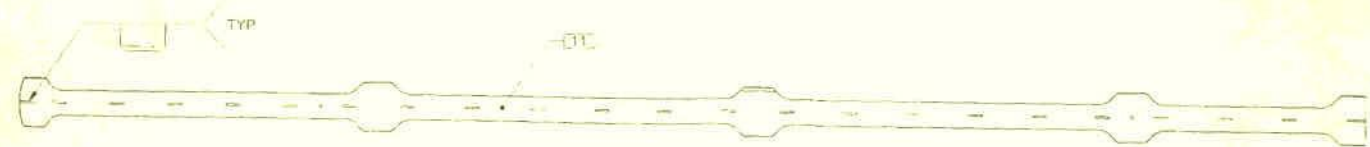


D4154-041 WEARPLATE ASSEMBLY

RELEASED
2012-04-11

REV	DESCRIPTION	BY	DATE
C	REVISE NOTE 9 (ZN AB-2) ADD HARDCOAT (ZN B7-2) ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1) REMOVED FINISH TO NOTE 2 (AB-2) REMOVED SECTION A-A (NO LONGER REQUIRED) REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	RC	10.07.22
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D4154 TITLE WEARPLATE ASSEMBLY SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	12.02.21		

83220



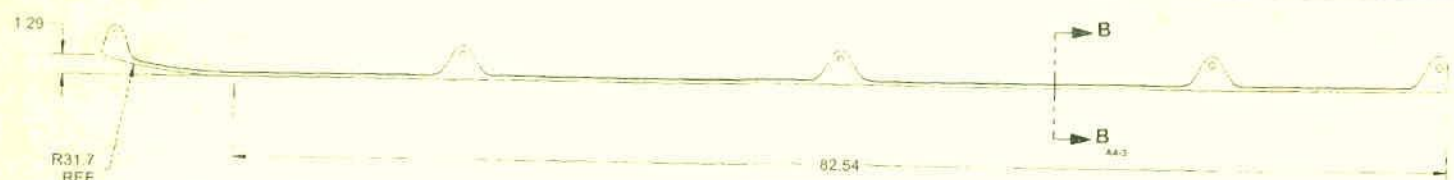
D4154-041 WEARPLATE ASSEMBLY

RELEASED
2012-04-11

- NOTES
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 6.88 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL
 - 10) TRANSFER DRILL \varnothing 0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
 - 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
 - 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

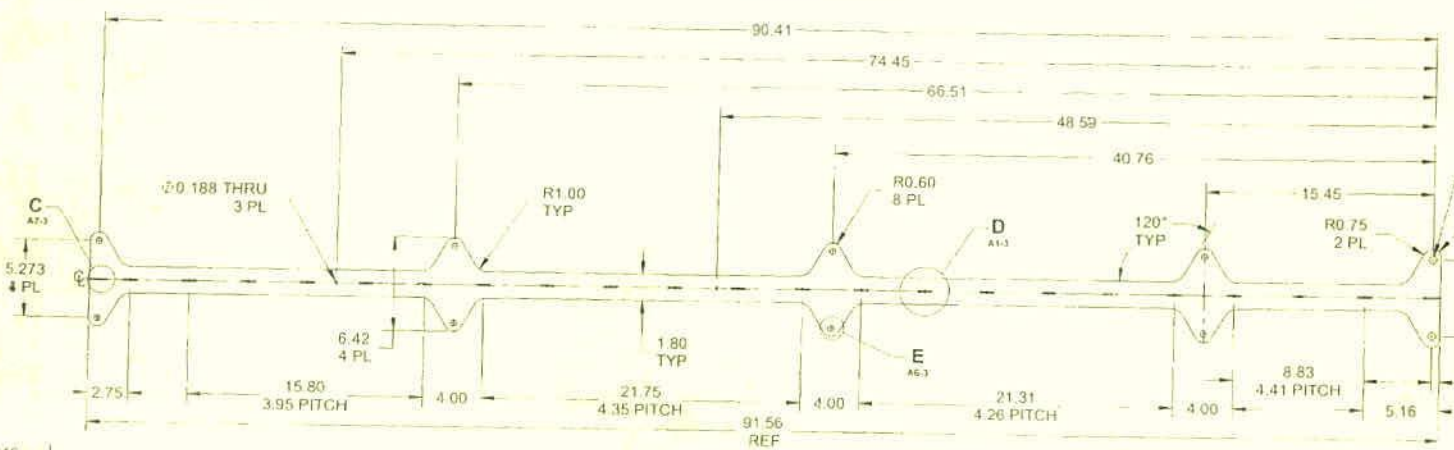
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, VA	
CHECKED		DRAWING NO	REV. C
MFG. APPR.		D4154	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	12.02.21	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	

23220

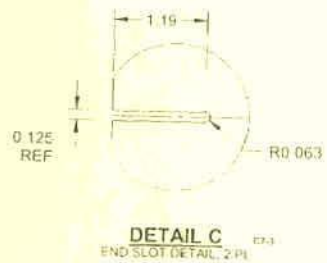


D4154-1 PLATE
(MAKE FROM D4154-1F)

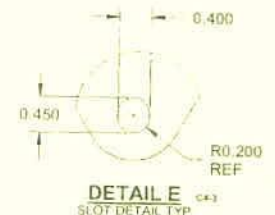
RELEASED
2012-04-11



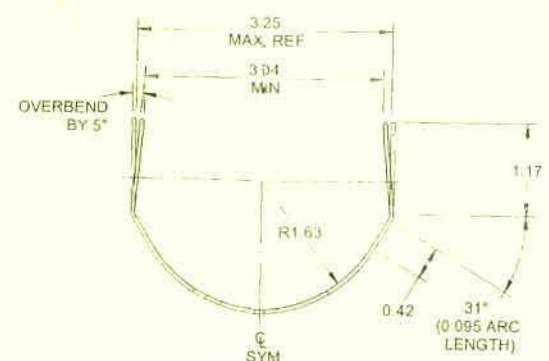
D4154-1F FLAT PATTERN



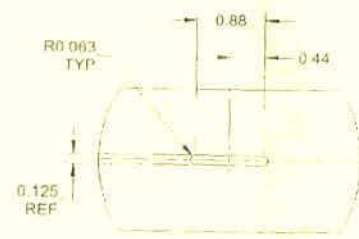
DETAIL C
END SLOT DETAIL, 2 PL



DETAIL E
SLOT DETAIL TYP



SECTION B-B



DETAIL D
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF: DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.95 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4154	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	12.02.21	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 12.05.03	Job No.: RD3403	ADR Yes/No: N	ADR Date: 12.05.03	ECN #: 12- 582
Product No.: D350-636		Created By: RF	Approved By: RF	
Product Name: Skidtube Installations		Checked By: RF		

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LL/MP	
Purchasing Coord.	Y	CL	
Production Engineering Coord.	Y	EC/DD	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.	N		
QC Coordinator	N		
Customer Technical Support	N		
Marketing	N		
Customer Order Processing	N		

Reason for Change: Revise D4154 per Production feedback.
Product Improvement

Documents Affected:
D4154 Rev. D

PARTS MUST COMPLY



PREVIOUS PARTS SATISFACTORY



#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	N		UPDATE MDL NEXT UPDATE	
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		12.05.09
11	Update Product Specification Files	N			
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.05.09
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update PPP's	N			
20	Red Decals required?	N			
21	Update Document Control Database / Laminated Dwgs	N	ME		
22	Update Grey Project / Electronic Binder PDF Files	N	ME		
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		12.05.09
24					

Description / Action:

Update BOM/routing for D4154 Rev. D
D4154-1F Flat Pattern per Rev. C can be rework by plugging the holes while making D4154-041 and transfer the holes using drawing D4154 Rev. D
Update D4154 water jet program per D4154 Rev. D dxf.

stlu -13 X D4154-1
1-66312
12-83217

S - 83220
S - 83219
8 - 83693

ECN Verified & Complete: _____

Date: _____

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 12.05.03	Job No.: RD3403	ADR Yes/No: N	ADR Date:	ECN #: 12- 582
Product No.: D350-636		Created By: RF	Approved By: <i>[Signature]</i>	
Product Name: Skidtube Installations		Checked By: <i>[Signature]</i>		

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LL/JM	
Purchasing Coord.	Y	CL	
Production Engineering Coord.	Y	EC/DD	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.	N		
QC Coordinator	N		
Customer Technical Support	N		
Marketing	N		
Customer Order Processing	N		

Reason for Change: Revise D4154 per Production feedback.
Product Improvement

Documents Affected:
D4154 Rev. D

PARTS MUST COMPLY



PREVIOUS PARTS SATISFACTORY



#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	N		UPDATE MDL NEXT UPDATE	
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		12.05.09 <i>[Signature]</i>
11	Update Product Specification Files	N			
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.05.09 <i>[Signature]</i>
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update PPP's	N			
20	Red Decals required?	N			
21	Update Document Control Database / Laminated Dwgs	N	KB		
22	Update Grey Project / Electronic Binder PDF Files	N	KB		
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		12.05.09 <i>[Signature]</i>
24					

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S-83220

S-83219

8-83693

ECN Verified & Complete: _____

Date: _____

